

Date: Monday, 28/04/2008 8:13:24 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LITTER DECKPLATE 350
 Job Number : 38810
 Estimate Number : 10357
 P.O. Number :
 This Issue : 28/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 36850
 Part Number : D2344
 Drawing Number : D2344 REV F
 Project Number : N/A
 Drawing Revision : F
 Material :
 Due Date : 15/05/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JLD 08-4-28
 Comment : Est Rev:D 00.06.26 Removed P/O for powder coat EC
 Est Rev:E 07-07-04 Asper Rev F JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



19



Comment: Qty.: 0.7823 sf(s)/Unit Total : 15.6450 sf(s)

Material: 2024-T3 QQ-A-250/5) .063

Batch 162942

B 8-4-29

(22)

2.0 WATER JET FLOW WATER JET



F
F

B 8-4-29



Comment: FLOW WATER JET

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-4-29



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 28/04/08 (22)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL/MED FAB

1-Deburr sharp edges

B 8-4-29

2-Countersink holes per Dwg D2344

B 08/05/01 (22)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:13:24 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER DECKPLATE 350

Job Number: 38810

Part Number: D2344

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/02 X22

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.F. 08/05/02

22X

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 8:30am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00am

08-05-02

X22

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.F. 08/05/02

22X

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Identify and Stock

Location: 185

8/5/02

22X

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/06

Job Completion



M.F. 08-05-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38810
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

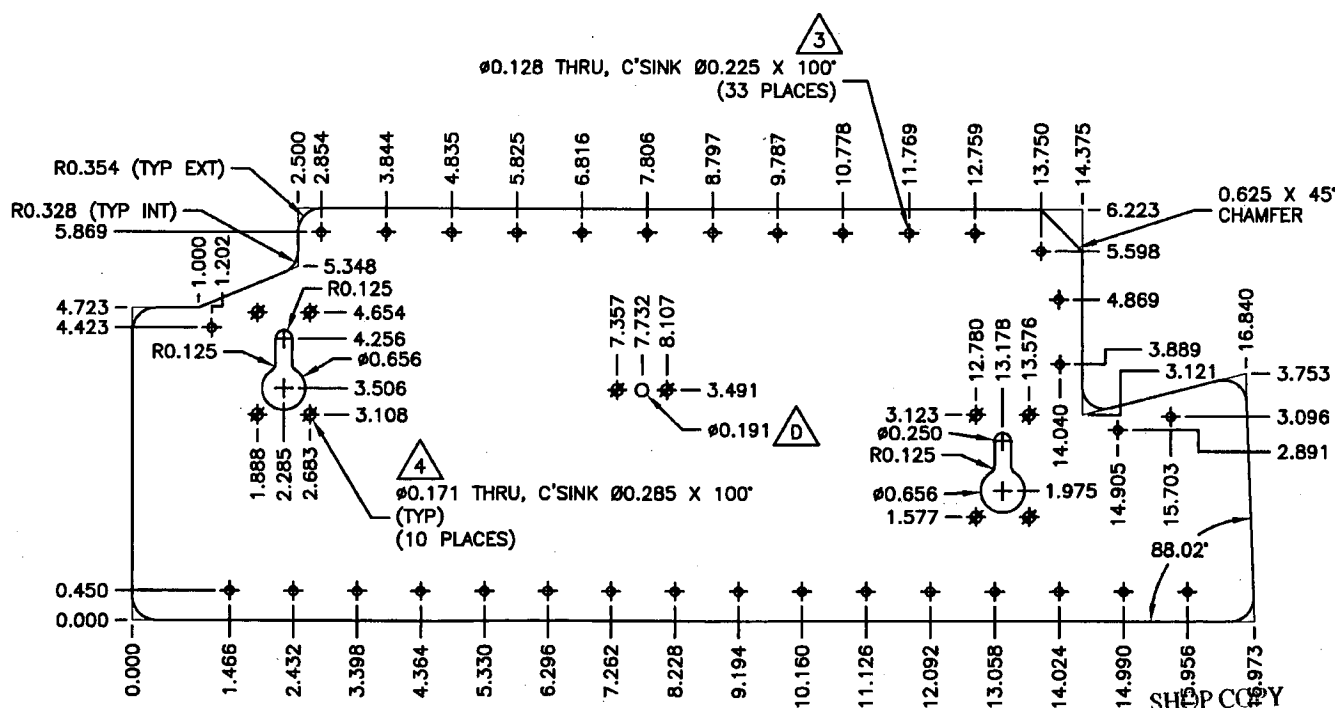
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.228	*			
5.598	+/-0.010	5.599	*			
4.869	+/-0.010	4.871	*			
3.889	+/-0.010	3.894	*			
3.096	+/-0.010	3.098	*			
2.891	+/-0.010	2.894	*			
16.973	+/-0.010	16.973	*			
0.450	+/-0.010	.450	*			
4.423	+/-0.010	4.425	*			
4.723	+/-0.010	4.723	*			
1.202	+/-0.010	1.202	*			
5.869	+/-0.010	5.871	*			
4.654	+/-0.010	4.655	*			
Ø0.656	+0.005/-0.000	.656	*			
1.888	+/-0.010	1.888	*			
2.285	+/-0.010	2.285	*			
2.683	+/-0.010	2.681	*			
Ø0.171	+0.005/-0.000	.171	*			
3.491	+/-0.010	3.494	*			
Ø0.191	+0.005/-0.000	.191	*			
3.123	+/-0.010	3.125	*			
1.975	+/-0.010	1.973	*			
Ø0.128	+0.005/-0.001	.130	*			

Measured by: HB	Audited by: S	Prototype Approval:	N/A
Date: 8-4-29	Date: 08/04/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	BE

DESIGN KE		DRAWN BY JC		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB		APPROVED HJ		DRAWING NO. D2344	
DATE 07.06.07		TITLE LITTER DECK PLATE, 350		REV. F SHEET 1 OF 1	
A	95.01.14	NEW ISSUE			
B	95.02.09	MOVED KEY HOLES			
D	95.03.06	0.191 WAS 0.197			
E	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)			
F	07.06.07	C'SINK Ø0.285 WAS Ø0.308			



14.3
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

D2344 LITTER DECK PLATE. 350

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4 WITHOUT NOTICE
(REF. DART SPEC. M2024T3S) WORK ORDER NO. 38810
- 2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) COUNTERSINK HOLES MARKED ~~Φ~~ TO Ø0.225 X 100'
- 4) COUNTERSINK HOLES MARKED ~~Φ~~ TO Ø0.285 X 100'
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N "02344" USING WHITE PAINT MARKER
- RELEASED

RELEASED

07.06.22

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